

Work Order ID 57563

April 8, 2010 10:26:30 AM



Page 1

Item ID: D3208-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 4/08/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3208	Rev A1								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3208 ☐ Dwg Rev: A1 ☐ Prog Rev: A1 ☐ 2-
Deburr if necessary

2624 .040

Deburr m-l w/04/13 (16x) (16)

1310-4-13

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1310-4-13

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/14

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57563

April 8, 2010 10:26:30 AM



Page 2

Item ID: D3208-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 4/08/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

(16) / BR 10-11-14

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/04/10

(16) /

150

Identify as per dwg & Stock Location: 45

0.00



Packaging

Memo

0.00

Packaging

10-4-15 (16x) SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 57563

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April 8, 2010 10:26:31 AM

Item ID: D3208-11

Accept



Setup Start



Revision ID:

Stop



Item Name: Filler

Start Date: 4/08/10 Start Qty: 10.00



Cust Item ID:

Required Date: 4/16/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/19 *[Signature]**MF*
10-4-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

April 8, 2010 10:26:29 AM

Page 1

Work Order ID: 57563



Parent Item: D3208-11



Parent Item Name: Filler

Start Date: 4/08/10

Required Date: 4/16/10

Comments: IPP: A ☐ 04.06.09 ☐ New issue ☐ KJ/RF ☐

Start Qty: 10.00

Required Qty: 10.00

IPP B 08.11.17 Waterjet EC verified: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	421.9000	1.7326			



2024-T3 .040 sheet

1810-4-13

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT22

421.9

110305

147.9

111786

18

112291

32

112331

64

113162

160

110305

16

W/O:		WORK ORDER CHANGES					
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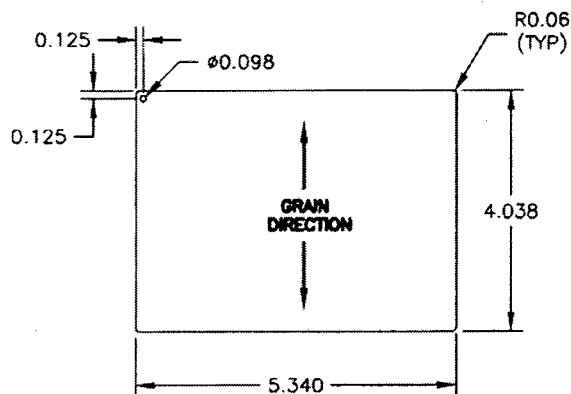
NOTE: Date & initial all entries



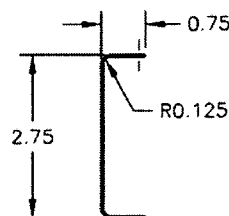
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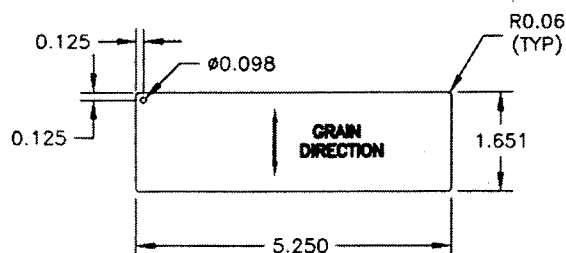
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AI	04.01.25	REVISED, LATE 31 2004



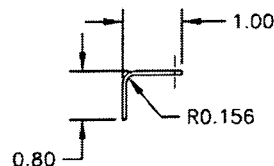
2 D3208-1 DOUBLER
FLAT PATTERN



D3208-1 DOUBLER
BEND DETAIL



3 D3208-3 PEDAL MOUNT ANGLE
FLAT PATTERN



D3208-3 PEDAL MOUNT ANGLE
BEND DETAIL

NOTES:

- 1) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040" THICK (M2024T3S.040)
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063" THICK (M2024T3S.063)
- 4) MATERIAL: 2024-T3 (QQ-A-250/4) 0.080" THICK (M2024T3S.080)
- 5) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES



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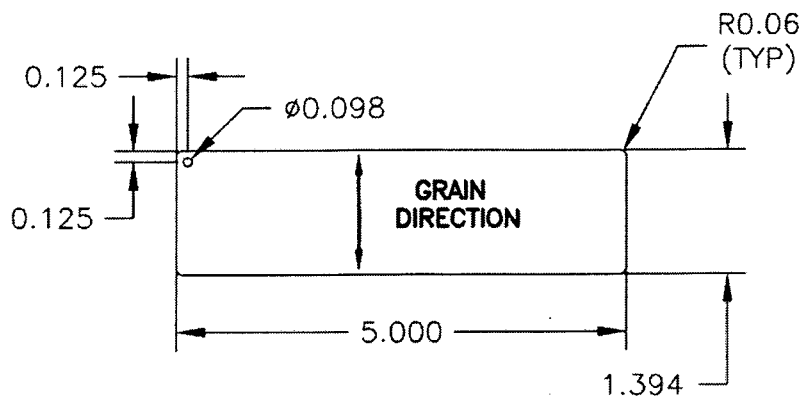
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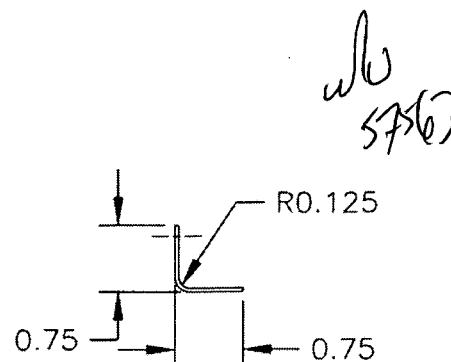


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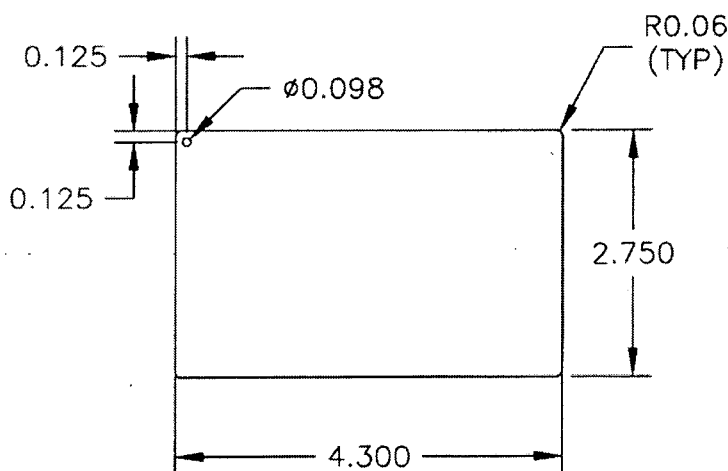
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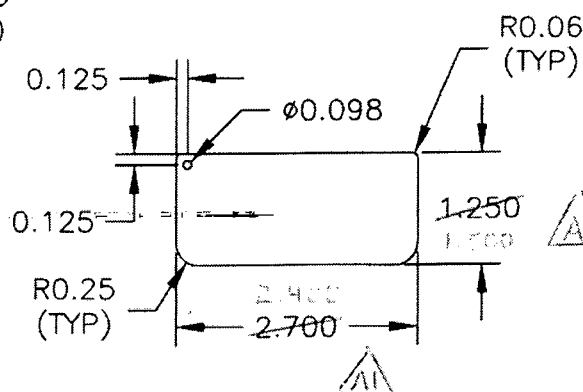
2 D3208-5 MOUNT ANGLE
FLAT PATTERN



D3208-5 MOUNT ANGLE
BEND DETAIL



2 D3208-7 FILLER



2 D3208-11 FILLER

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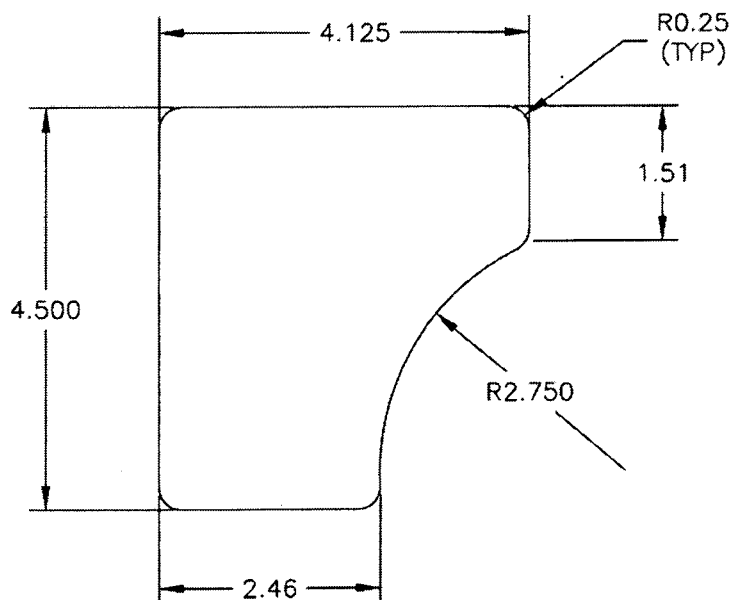
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WLO
57563



D3208-9 DOUBLER

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